

MAMMOMAT 1000 / 3000

SP

Service

Replacement of parts

Connector X8 on filament cable,
AMP-plug crimping kit

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General

This instruction describes how to replace the AMP plug X8 on the end of filament heating cable in the generator of the systems MAMMOMAT 1000 / 3000.

The filament current is conducted from its source to the cathode via the connector X8.

The AMP socket with the female contacts (sleeves/bushings) is soldered to the backplane D700.

The AMP plug with the male contacts (pins) is crimped to the end of filament heating cable, which is a part of the main cable harness.

It was observed that these contacts may get overheated and burnt. The repair can be performed e. g. by replacing either the backplane D700 or the main cable harness, or both - in cases when the male and female contacts of this connector X8 are equally badly damaged.

In order to have an alternative to the exchange of the whole main cable harness the "Repair kit Plug X8 on Filament cable" was created and can be now ordered via CS ML under the material no. **86 20 523**.

This kit can be used to replace the burnt AMP plug on the end of the filament cable. Should the socket on the D700 be also damaged, at present there is no alternative to the exchange of the whole backplane.

The **X8 plug repair kit 86 20 523** consists of:

Item:	Mat No.	Name	Quantity:
1)	70 61 369	Crimping tool (pliers);	1
2)	31 61 908	AMP Plug housing;	5
3)	10 20 098	Contact pin BD SN III+ 0.75-1.52 Q GE C;	50
4)	70 61 377	AMP Pin Extractor 725840-1;	1
5)		This instruction	1

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The kit contains some 5 housings and 50 pins, it is intended for several occasions, should provide the possibility of up to five repairs.

Documents required

The technical documentation supplied along with the MAMMOMAT is required. That documentation should be used when instructions how to open the generator and how to access the connector X8 are required. Such descriptions can be found e. g. in Installation and Start-Up Instructions.

NOTICE

When working on MAMMOMAT system, here mainly on the generator, all Protective measures described in pertaining instructions have to be unconditionally observed. Especially the protective measures as listed in the Chapter 2 of the Installation and Start-Up Instructions have to be followed.

Work steps

- 1) Get access to the connector X8 No: 2 in Figure 1) on the backplane D700 of the generator.

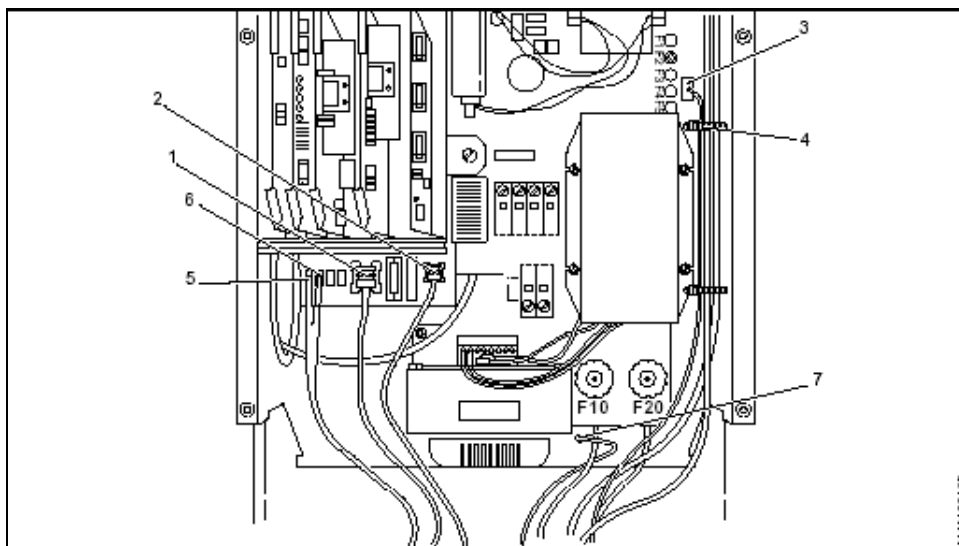


Fig. 1 Generator

- 2) Disconnect - unplug X8;
- 3) Thoroughly investigate both, the socket X8 on the backplane and the plug X8 on the filament heating cable;
- 4) If female contacts (sleeves/bushings) of the socket X8 on the backplane are burnt beyond possibility of further use, proceed with the exchange of backplane D 700;
- 5) If male contacts (pins) of the plug X8 are burnt, proceed with repair-exchange according to further steps here.
- 6) Mark and memorize the location of wires in the AMP plug X8; extract the contact pins with the supplied extractor, then cut them away near to the terminal;

7) Prepare the wires for new crimping;

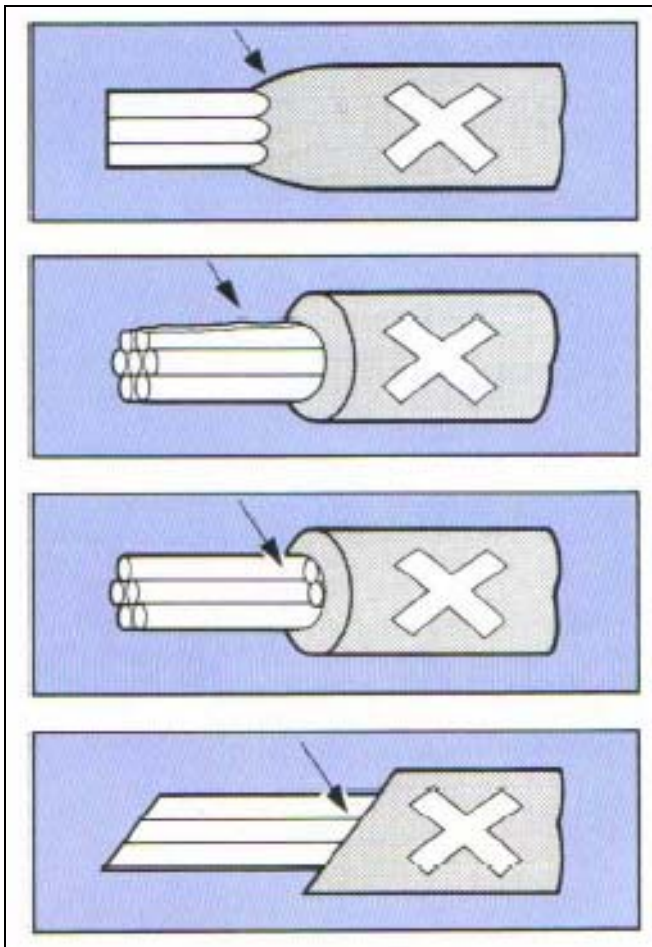


Fig. 2

Incorrect: Stripping blades are too far apart, insulation is torn, not clearly cut,
 Stripping blades are too close together, strands are scrapped or even missing;
 Stripping blades are too close together, strands are cut away;
 Stripping blades are out of alignment;

Correct, this is a good strip:

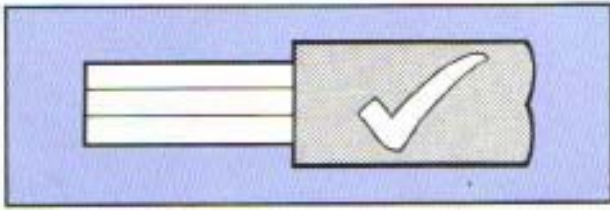


Fig. 3

- 8) Position the prepared wires correctly in the supplied crimping tool and press until automatically released,
- 9) Inspect the crimping according to following picture (note: the terminal in the picture is slightly different than the pin supplied);

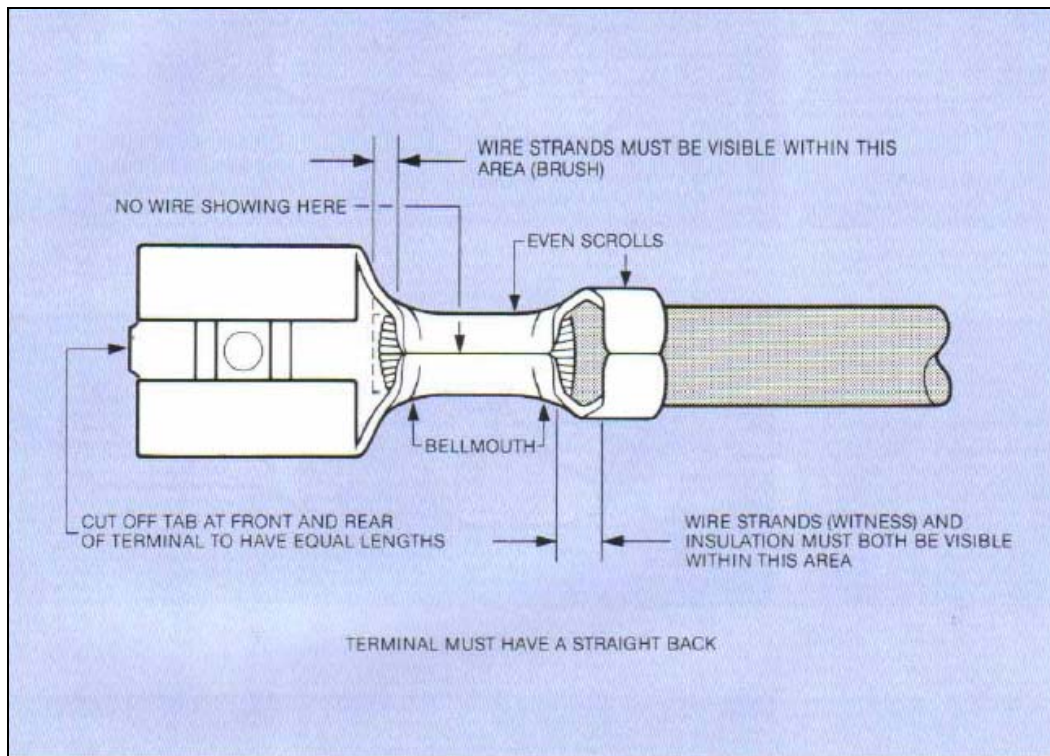


Fig. 4

- 10) Proceed with other wires, when completed insert into one of the new supplied plug housings; listen to clicking sound when pins snap into place, crosscheck secure fixation by moderate pull of wire.
- 11) Reconnect the plug and the socket;
- 12) Check operation of generator, re-assemble the cover.

Perform functional check of the operation of the MAMMOMAT before handing over the system to the customer.

